

Work Order ID 153575

Tuesday, November 22, 2016 9:41:34 AM

153575

Page 1

Item ID: D4482-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Hinge Plate, RH

Start Date: 11/28/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/2/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

VS

DAS
21
9-89

Date:

11/14/22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4482

C

DAS
46
9-89

11/11/22

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4482-3 as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

4

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

DAS
46
9-89

4

11/11/22

DAS
38
3-89
NOV 23 2016

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Page 3

4 _____

DAS
41
~~99~~
16-11-30

Work Order ID 153575

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153575

Page 4

Item ID: D4482-4 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Hinge Plate, RH
Start Date: 11/28/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 12/2/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC14- Inspect Spray Paint	0.00							
180									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
190	Identify as per dwg & Stock Location: SHOB	0.00							
190									
Packaging	Memo	0.00							DAS 6 9-89
Packaging									4 DEC 05 2016
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							DAS 21 9-89
Quality Control									DEC 05 2016

16-12-05

Picklist Print

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Page 1

Work Order ID: 153575

153575

Parent Item: D4482-4

D4482-4

Parent Item Name: Hinge Plate, RH

Start Date: 11/28/2016

Required Date: 12/2/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:B 13.01.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080

Purchased

No

sf

113.9800

0.505263

DAS
46
9-89

16/11/22

M6061T6S 080

6061-T6 .080 Sheet

**

Location

Loc Qty

Loc Code

MAT020

113.98

134217

9.1

m132772

4.3

m133587

7.7

m133828

2.6

m134551

7

m134830

19.9

m135147

18.07

m135559

12.71

m135861

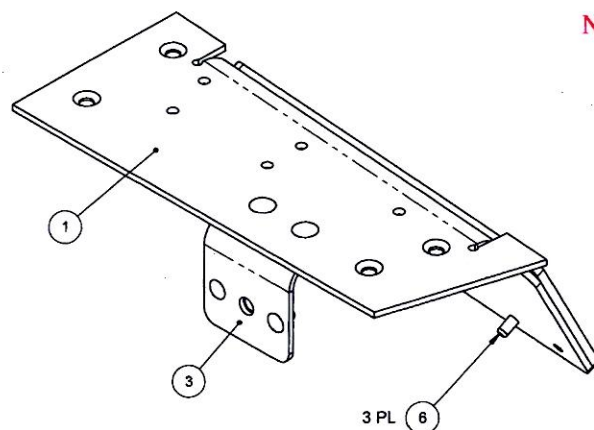
32.6

0.48

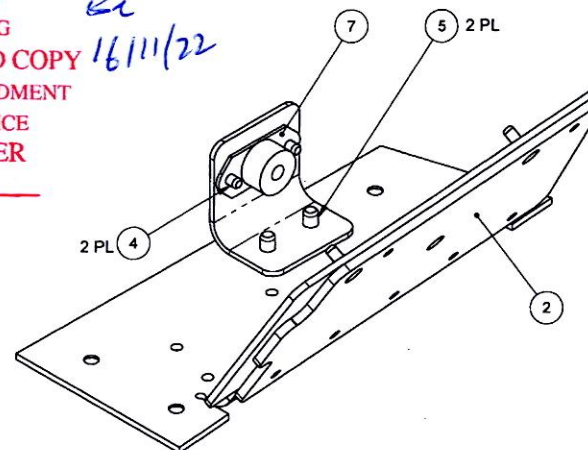
ITEM	QTY	P/N	DESCRIPTION
	X	D4482-041	INTERCOSTAL 5 ASSY (LH)
1	1	D4482-1	INTERCOSTAL 5 (LH)
2	1	D4482-3	HINGE PLATE (LH)
3	1	D4488-1	CLIP
4	2	MS20426AD3-3	RIVET, CSK
5	2	MS20426AD4-4	RIVET, CSK
6	3	MS20426AD3-5	RIVET, CSK
7	1	MS21059L08	NUTPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155575

*Vic
K2
16/11/22*



D4482-041 INTERCOSTAL 5 ASSY (LH)

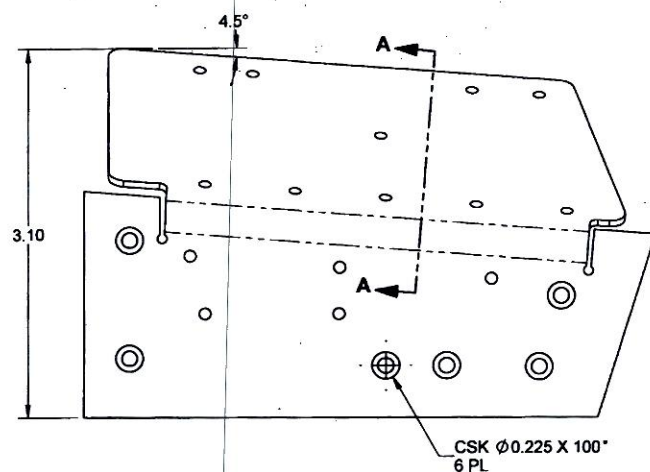


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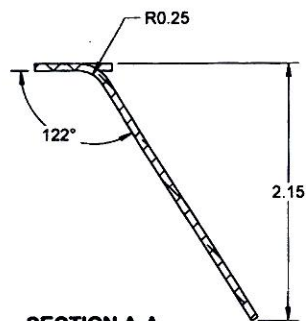
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

C	ADDED -042 & -2 (RH CONFIGURATION).	AJS	12.10.05
B	GENERAL REVISION SEE REV. A FOR DETAILS. ADDED -3. ADDED PRIMER NOTE.	AJS	12.09.11
A	NEW ISSUE	AJS	12.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4482	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	INTERCOSTAL 5 ASSY	NTS
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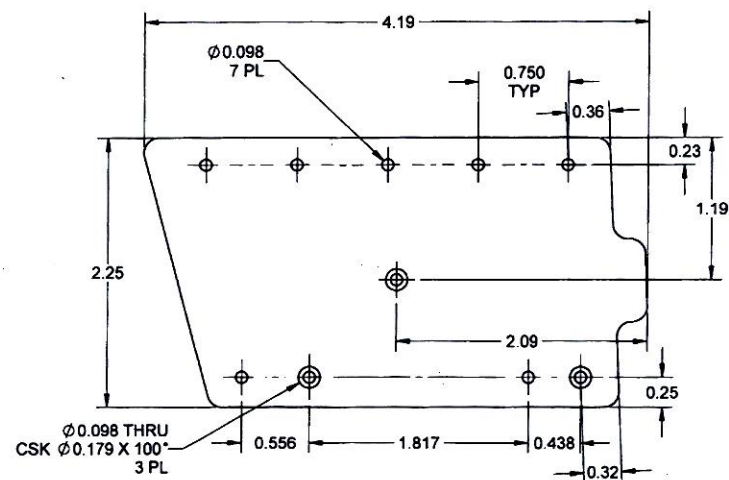
D4482-1 INTERCOSTAL 5 (LH)



SECTION A-A

NOTES:

- 1) MATERIAL: MAKE FROM D4482-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



D4482-3 HINGE PLATE (LH)

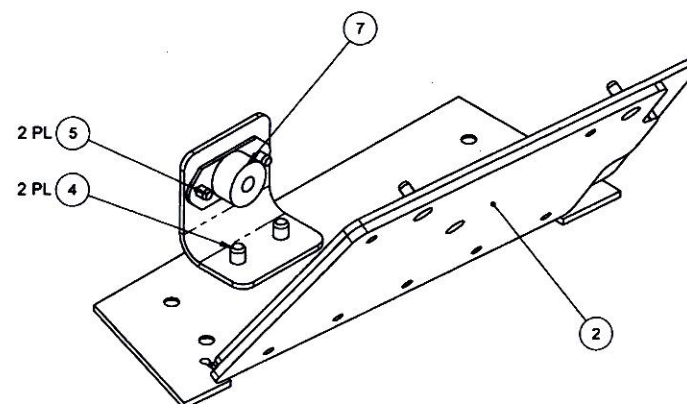
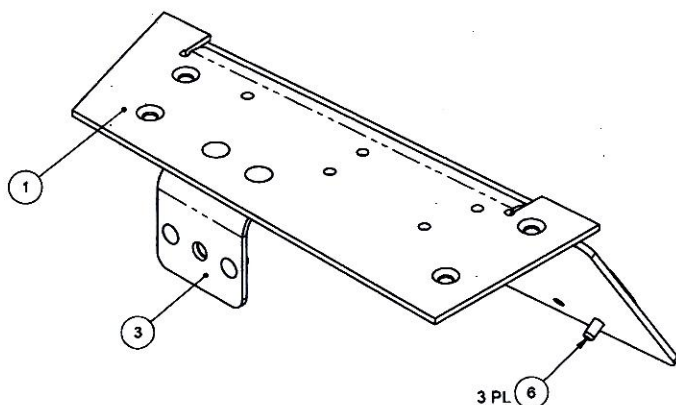
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4482-3-REV.C.DXF"

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	R	DRAWING NO.	REV. C
MFG. APPR.		D4482	SHEET 2 OF 5
APPROVED	AP	TITLE	SCALE
DE APPR.		INTERCOSTAL 5 ASSY	NTS
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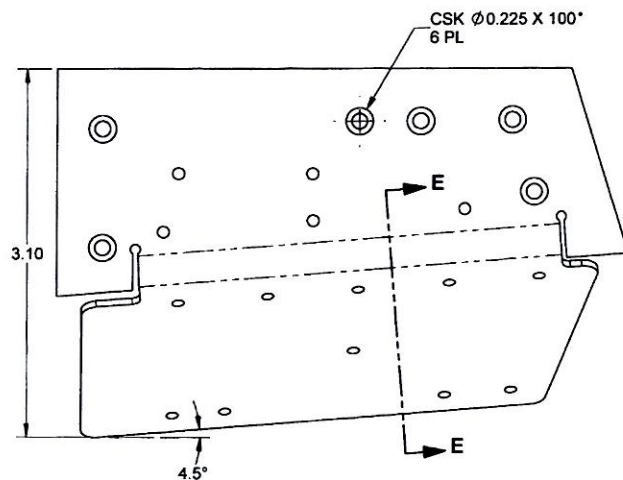
ITEM	QTY	P/N	DESCRIPTION
	X	D4482-042	INTERCOSTAL 5 ASSY (RH)
1	1	D4482-2	INTERCOSTAL 5 ASSY (RH)
2	1	D4482-4	HINGE PLATE (RH)
3	1	D4488-1	CLIP
4	2	MS20426AD4-4	RIVET, CSK
5	2	MS20426AD3-3	RIVET, CSK
6	3	MS20426AD3-5	RIVET, CSK
7	1	MS21059L08	NUTPLATE



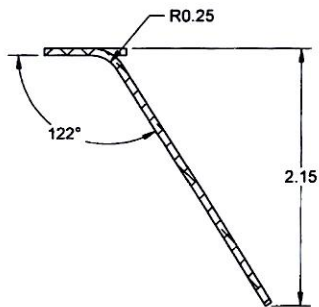
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	97	DRAWING NO.	REV. C
MFG. APPR.	12	D4482	SHEET 3 OF 5
APPROVED	12	TITLE	SCALE
DE APPR.	12	INTERCOSTAL 5 ASSY	NTS
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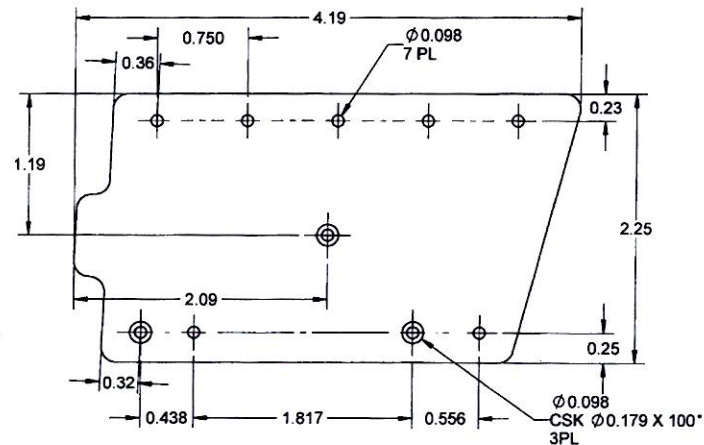
D4482-2 INTERCOSTAL 5 ASSY (RH)



SECTION E-E

NOTES:

- 1) MATERIAL: MAKE FROM D4482-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



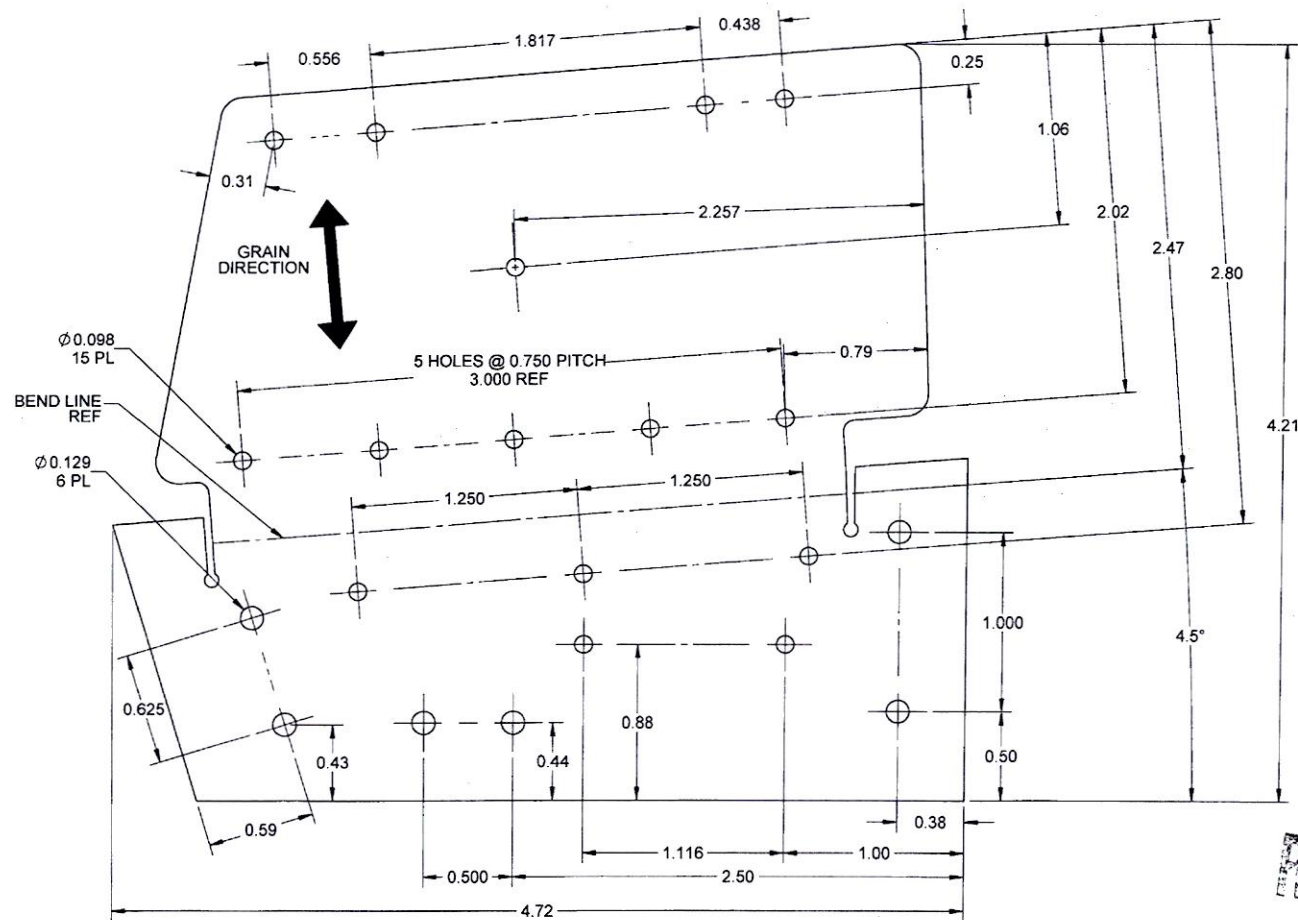
D4482-4 HINGE PLATE (RH)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4482-3-REVC.DXF"

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MFG. APPR.	<i>[Signature]</i>	D4482	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	INTERCOSTAL 5 ASSY	NTS
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- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.10 lbs
 - 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4482-1F-REVC.DXF"

D4482-1F INTERCOSTAL 5
(FLAT PATTERN)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4482	REV. C
MFG. APPR.	<i>[Signature]</i>		SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE INTERCOSTAL 5 ASSY	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.10.05		

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